DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-025938
Date Inspected: 08-Aug-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Watson Bowman Acme Corp

OSM Arrival Time: 800
OSM Departure Time: 1630
Location: Buffalo, NY

CWI Name: Greg Ross

Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**CWI Present:**	☑ Yes	☐ No		
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A	
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A	
Approved Drawings:	☐ Yes	☑ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A	
				Approved WPS:	☐ Yes	☑ No	☐ N/A	
				Delayed / Cancelled:	☐ Yes	☐ No	☑ N/A	

Bridge No: 34-0006
Component: Seismic Joint Hinge A

Summary of Items Observed:

On this date, Quality Assurance Inspector (QAI) Dustyn Broening was present at the Watson Bowman Acme Corporation (WABO) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A for the San Francisco Oakland Bay Bridge (SFOBB) project.
This (QAI) met with Watson Bowman Acme Corporation Quality Control Manager (QCM) Mr. Gregory Ross.
This QAI observed certified welder Jayson Gray (welder ID#J) using the FCAW process (dual shield, 100%CO2), filler metal TM-811N1, to weld fillet welds on SEI112667CA2 5, SEI112667CA2 6, SEI112667CA2 7 and SEI112667CA2 8 (4 assemblies) of (24ea required) Channel Assemblies are being worked on at this time. Welds are being performed on the Top Plate to Stiffener Plate connections. All welding was being performed in the 2F position and are being installed within the parameters of unapproved WPS #FCAW-11 (reference Incident Report #87). Dimensions were checked per SMR Bahjat Dagher request and were verified to be acceptable at time of inspection. It was noted that a tight fit was achieved in lieu of a “mill to bear” as specified in RFI ABF-RFI-002507R00 on Top Plate to Stiffener connections. This tight fit was found to be in accordance with revised unapproved Drawing B-24952 revision 11, and AWS D1.5 section 3.5.1.9. Joint preparations on the bottom side of the Stiffener Plates were found to be acceptable and in accordance with above referenced revised drawings. See attached photos.

WELDING INSPECTION REPORT

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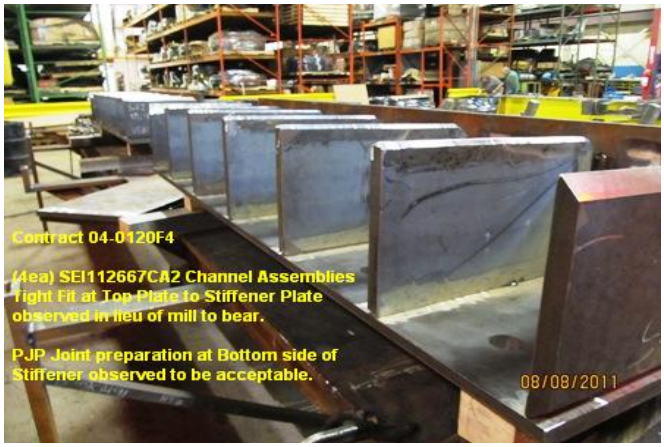

Summary of Conversations:

Other basic communication was performed between the QA Inspector and the QC Manager.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Broening,Dustyn	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer